



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5468-1

Job Sheet 187834



Part No: D5468-1

Job Qty: 4 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Machining-4		SBZ 18/12/19
100	CNC Vertical Machining	4 pcs	1/11/19	1/11/19	0.00	7.92	HAAS1-1		UHS 18/12/21
120	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC8 Machining-4		
140	HandFinish	4 pcs	1/11/19	1/11/19	0.00	0.56	HandFinish1		
150	SprayPaint	4 pcs	1/11/19	1/11/19	0.00	0.10	Spray Paint		
160	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC14		
170	Packaging	4 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2	51399	JAN 23 2019
180	QC21-SA	4 Ea	1/11/19	1/11/19	0.00	0.00	QC21		21 JAN 23 2019

Part Op 100 - Program Batch No. 138980 Double check by: JJ 1-Machine Step No 1 per Folio FB548 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp

150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH:

163: Outsource - Atelier - P0042232-92 19-01-10

165: Receiving 4X JAN 17 2019

167: QC 6

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5133600

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	4	17	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skip ☐ Machine ☐ Lathe	DEPARTMENT/PROCESS Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐ Part: D5468-1 Job No: 187834 Serial No/Batch: S138980 Revision: A Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/19/18 Container No: S138980 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Date : _____	Sequence #: _____	QTY: _____	MRB (QSI042)
Description Work Order Deviation		Completed By	
Lead hand / Supervisor		QC / QA Coordinator	

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details:	

DART AEROSPACE LTD		Work Order: 187834
Description: Outer Aft Saddle		Part Number: D5468-1
Inspection Dwg: D5468 Rev. A		Page 1 of 1

Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge		
A	0.438	0.443			
B	1.745	1.755			
C	3.495	3.505			
D	1.745	1.755			
E	7.990	8.010			
F	0.490	0.510			
G	0.257	0.262			
H	0.375	0.380			
I	0.490	0.510			
J	1.174	1.184			
K	0.558	0.578			
L	1.174	1.184			
M	1.365	1.375			
N	2.495	2.505			
O	4.119	4.129			
P	0.115	0.135			
Q	0.115	0.135			
R	0.240	0.260			
S	0.115	0.135			
T	0.178	0.198			
U	3.210	3.250			
V	0.230	0.250			
W	0.115	0.135			
X	0.308	0.313			
Y	0.760	0.765			
Z	0.352	0.372			
AA	0.470	0.530			
AB	0.615	0.635			
AC	0.053	0.073			
AD	0.240	0.260			
AE	1.500	1.520			
AF	0.115	0.135			
AG	0.240	0.280			
AH	0.240	0.260			
AI	2.000	2.020			
AJ	0.023	0.043			
Accept/Reject					

Measured by: VAS	Audited by: JAK
Date: 18/12/21	Date: 19/01/05



Dart Aerospace Ltd.
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K6A 1K7
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PURCHASE ORDER

PO042232



Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO042232
PO Date: 1/10/19
Due Date:
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187832	D5466-1	Saddle, Fwd, In : Various STC's ISSUE P/O: ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
2	187833	D5467-1	Saddle, Fwd, Out : Various STC's ISSUE P/O: ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00



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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	187834	D5468-1	Saddle, Aft, Out : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
4	187835	D5469-1	Saddle, Aft, In : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
Grand Total:											\$400.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.